

Work Order ID 97771

February-22-13 10:59:56 AM

97771

to Rev A 8/13/0/27

ISSUE

Page 1

Item ID: D4753-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Stop

NS2

Item Name: Doubler

Start Date: 2/22/13

Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/01/13

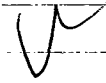
Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4753

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D4753

Dwg Rev: PA1

Prog Rev: PA1

2- Ream center hole at .750" as per dwg.
3- Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

8

0

Jm 13-2-27

29

0

Jm 13-3-8

8

0

Jm 13-2-27

29

0

Jm 13-3-8

97771

February-22-13 10:59:56 AM

N900040100

Setup Start *NS1*

Stop *NS2*

8

Cust Item ID:

8

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

120

120

HAAS 1

HAAS CNC vertical machine #1

Operation Description

HAAS CNC VERTICAL MACHINING #1

Memo

Machine as per Folio FB163 and Dwg D3506

Set Up/ Run Hours

0.00

0.00

Tool ID**Tool #****Plan
Code**

Accept
Qty

Reject
QtyReject
Number**Insp.
Stamp**

130

130

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

140

140

OC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

Work Order ID 97771

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Page 3

February-22-13 10:59:56 AM

Item ID: D4753-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: PRELIM Stop *NS2*
 Item Name: Doubler
 Start Date: 2/22/13 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 3/01/13 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Small Fab	0.00							
150	Small Fab	0.00				27x			
Small Fab	Memo	0.00							
Small Fab	C'sink as per Dwg D3506 (On Flat side)								
160	QC5- Inspect part completeness to step on W/O	0.00							
160	QC	0.00				27x			
Quality Control	Memo								
170	Chemical Conversion Coat per QS 005 4.1	0.00							
170	HandFinish	0.00							
Hand Finishing	Memo								

Took 16 for testing
 13.05.27

11 7613.5-27

13.05.13 For testing

Work Order ID 97771

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Page 4

February-22-13 10:59:56 AM

Item ID: D4753-1

Accept

N900040100

Setup Start *NS1*

Revision ID: PRELIM

Stop *NS2*

Item Name: Doubler

Start Date: 2/22/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/01/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

180

QC

Quality Control

QC7 Inspect Part Finish

Memo

0.00

0.00

13-5-31

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: _____

"Skidtube cell"

Memo

0.00

0.00

13-5-31 9

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

13/6/13

MCJ 13-5-31

POSITIVE RECALL

EFFECTIVE 1/20/12 AUTH U

RELEASED S DATE 13/05/13

to Rev A Dwg

Picklist Print

February-22-13 10:59:55 AM

Page 1

Work Order ID: 97771

Parent Item: D4753-1

Parent Item Name: Doubler

Start Date: 2/22/13

Required Date: 3/01/13

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 13-02-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	118.4162		0.1104			
6061-T6 .125 Sheet										0.25			Jm 13-2-27
										0.25			Jm 13-3-8
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT021		118.4161578							
				121473		0.9161578							
				123279		117.5							
										<u>123279</u>			

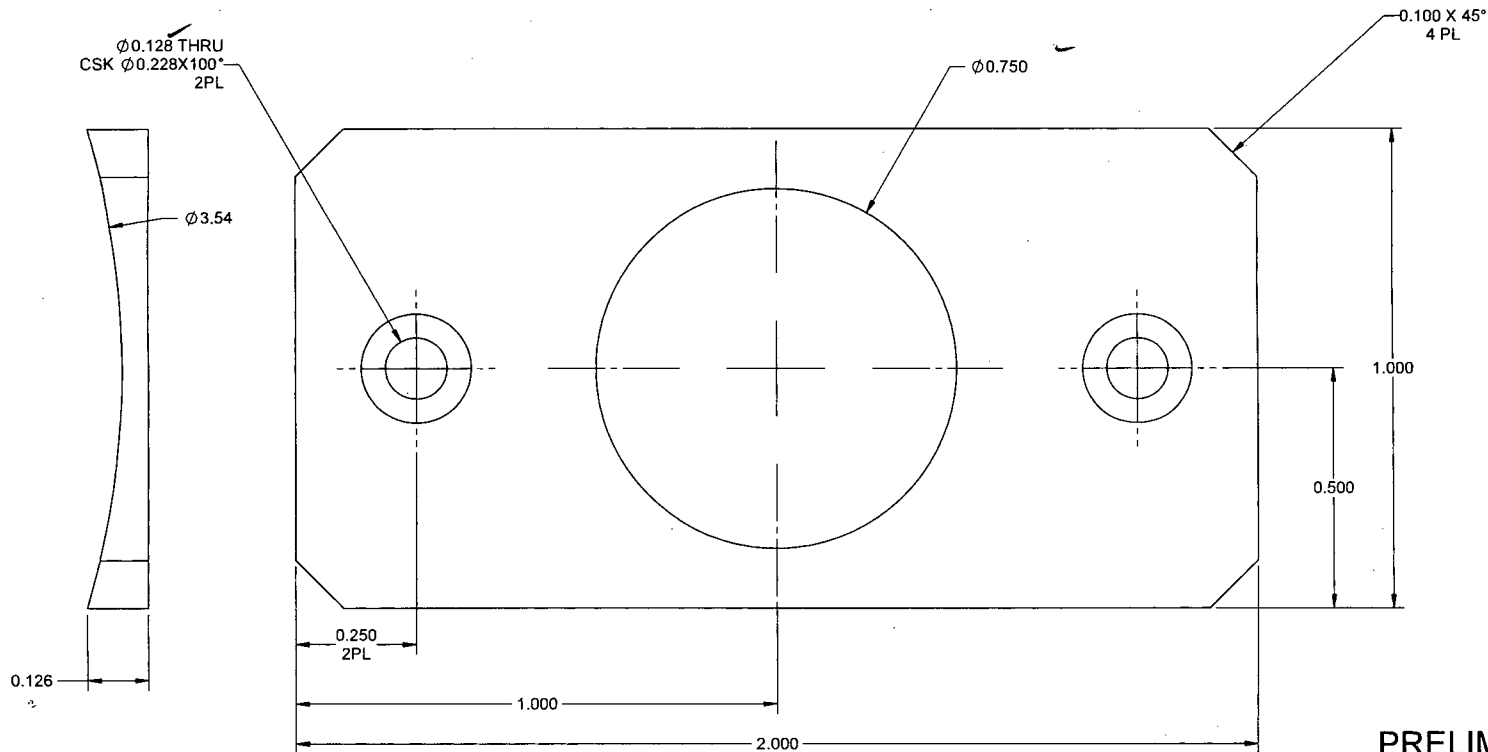
8 7 6 5 4 3 2 1

D

C

B

A



D4753-1 DOUBLER

PRELIMINARY A1
13.02.13 (AP)

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
REF DART SPEC M8061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" USING A MARKED BAG/BIN
- 7) WEIGHT: 0.01 lbs

w/097771

A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4753	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
DATE	13.02.13	<small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order: 97771
Description: Doubler		Part Number: D4753-1
Inspection Dwg: D4753 Rev: PA1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.128"	+0.005" -0.001"	0.131"	-		✓	Jkmo1
Ø 0.750"	+0.008" -0.001"	0.751"	-		✓	
1.000"	+/-0.010"	1.002"	-		✓	
0.500"	+/-0.010"	0.501"	-		✓	
0.250"	+/-0.010"	0.251"	-		✓	
1.000"	+/-0.010"	1.000"	-		✓	
2.000"	+/-0.010"	1.998"	-		✓	
0.125"	+/-0.010"	0.125"	-		✓	
Ø 0.128"	+0.005 -0.001 0.129"	0.129"	✓		✓	Jkmo1
Ø 0.750"	+0.008 -0.001	0.751"	-		✓	
1.000"	+/-0.010"	1.005"	-		✓	
0.500"	+/-0.010"	0.499"	-		✓	
0.250"	+/-0.010"	0.248"	-		✓	
1.000"	+/-0.010"	0.995"	-		✓	
2.000"	+/-0.010"	1.998"	-		✓	
0.125"	+/-0.010"	0.124"	-		✓	

2nd
Cut

Measured by: Jm	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 13-2-27	Date: 13-03-08	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15

8 7 6 5 4 3 2 1

D

C

B

A

0.126

Ø0.128 THRU
CSK Ø0.228X100°
2PL

Ø3.54

Ø0.758

0.100 X 45°
4 PL

1.000

0.500

0.750

1.500

2.000

D4753-1 DOUBLER

RELEASED
2013-03-25
m

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11
REF DART SPEC M6061T6S
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4753-1" AND B/N PER QSI 044 METHOD 6.7
- 7) WEIGHT: 0.01 lbs

A		NEW ISSUE		AP	13.02.13
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA		REV. A	
DRAWN	AP			SHEET 1 OF 1	
CHECKED		DRAWING NO.		TITLE	
MFG. APPR.		D4753		DOUBLER	
APPROVED		DATE		SCALE	
DE APPR.		13.02.13		NTS	
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8 7 6 5 4 3 2 1